

Date: Wednesday, 5/31/2006 7:38:47 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: 350 BASKET BASE (SHORT)	
Job Number	: 27293A		Part Number	: D3265041	
Estimate Number	: 10209		Drawing Number	: D3265 REV B	
P.O. Number	: N/A		Project Number	: N/A	
This Issue	: 5/31/2006 S.O. No. : N/A		Drawing Revision	: B	
Prsht Rev.	: NC		Material	: N/A	
First Issue	: N/A		Due Date	: 6/30/2006 Qty: 1 Um: Each	
Previous Run	: 27292A				
Written By	: <i>[Signature]</i> Comment (below)				
Checked & Approved By	: <i>[Signature]</i> 06-05-31				
Comment	: Est Rev:0 Re-Format 05-11-03 JLM				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :		
1.0	D31661	Basket Hoop		
		Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s) Qty 3 D3166-1 Basket Hoop Batch: B26259	PD	06-06-12
2.0	M304TS0750W065	304 SQ Tube.75x.75x.065W		
		Comment: Qty.: 19.2150 f(s)/Unit Total : 19.2150 f(s) 3/4" x 3/4" x 0.063" wall 304/316 SS tubing. (M304TS0.750W.065) Batch: M100783 → 51"	PD	06-06-12
3.0	D22323	Basket Hinge		
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Pick: Qty Part Number Description Batch 2 D2232-3 Hinge bracket B4527	PD	06-06-12
4.0	D2325	Support Gusset (350 Bask)		
		Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s) Pick: Qty Part Number Description Batch 4 D2325 Support Gusset B26741	PD	06-06-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries QA: N/C Closed: _____ Date: _____

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Seq. #:	Machine Or Operation:	Description :
5.0	D23273	Spacer Bushing
<p>Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)</p>		
<p>Pick:</p>		
Qty	Part Number	Description Batch
2	D2327-3	Bushing <u>B25823</u> PD 06-06-12
6.0	D2581	Mounting Bracket
<p>Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)</p>		
<p>Pick:</p>		
Qty	Part Number	Description Batch
2	D2581	Mounting Bracket <u>B25824</u> PD 06-06-12
7.0	D34425	Shim
<p>Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)</p>		
<p>Pick:</p>		
Qty	Part Number	Description Batch
2	D3442-5	Shim <u>B24246</u> PD 06-06-12
8.0	M304EX07516F	Expanded Metal Flat Stai
<p>Comment: Qty.: 26.0000 sf(s)/Unit Total : 26.0000 sf(s)</p>		
<p>Pick:</p>		
Qty	Part Number	Description Batch
26sf	M304EX0.75-16F	Expanded Metal <u>B241100081</u> PD 06-06-14
9.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
<p>Comment: LARGE FABRICATION RESOURCE 1</p>		
<p>1-CUT (3) D2235-1 FROM D3166-1</p>		
<p>2-Drill hole in D3265-3 as per Dwg D3265</p>		
<p>3-Remove all markings from material</p>		
<p>4-Weld as per Dwg D3265 using Welding Table and corner JigDeburr as required PD 06-06-14</p>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____

PAR #: _____

Fault Category: _____

NCR: Yes

DQA: 

Date: 06/06/27

NOTE: Date & initial all entries

QA: N/C Closed: _____

Date: _____

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Job Number:



Seq. #: Machine Or Operation:

Description :

10.0 QC9/6

DDIMENSIONAL & WELDING INSPECTION



Comment: DDIMENSIONAL & WELDING INSPECTION

DL 06/06/06 (1)

11.0 POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

DL 06/06/06 (1)

12.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Seal support gusset seam with White Sikaflex-291

Batch: M101126

M.F 06.06.22

Expiry date: 11/2006

13.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

(1)

14.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

15.0 DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

DL 06/06/22 (1)

Job Completion



U 06.06.22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____

PAR #: _____

Fault Category: _____

NCR: Yes No DQA: _____

Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____

Date: _____

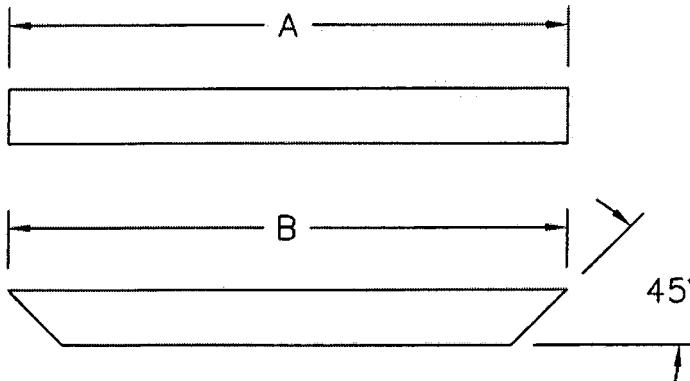
DART

DESIGN DS	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO. D3265	REV. B SHEET 1 OF 3
DATE 05.06.08	TITLE BASKET BASE ASSEMBLY (350)		SCALE NTS
A	04.02.02	NEW ISSUE	
B	05.06.08	ADD SHIM UNDER HINGES, ADD HOLES FOR SPLIT LID BASKETS	

RELEASED
05.08.19 *[initials]*

PARTS LIST FOR D3265-041 BASKET BASE ASSEMBLY

PART NO	QUANTITY	LENGTH A	LENGTH B	DESCRIPTION
D3265-1	2	—	56.75 ^v	RIB
D3265-3	2	—	25.50 ^v	RIB
D3265-5	2	27.25 ^v	—	RIB
D2232-3	2	N/A	N/A	HINGE PLATE
D2235-1	4	N/A	N/A	RIB
D2325	4	N/A	N/A	SUPPORT GUSSET
D2327-3	2	N/A	N/A	BUSHING
D2581	2	N/A	N/A	MTG BRKT
D3442-5	2	N/A	N/A	SHIM

D3265-1/-3/-5

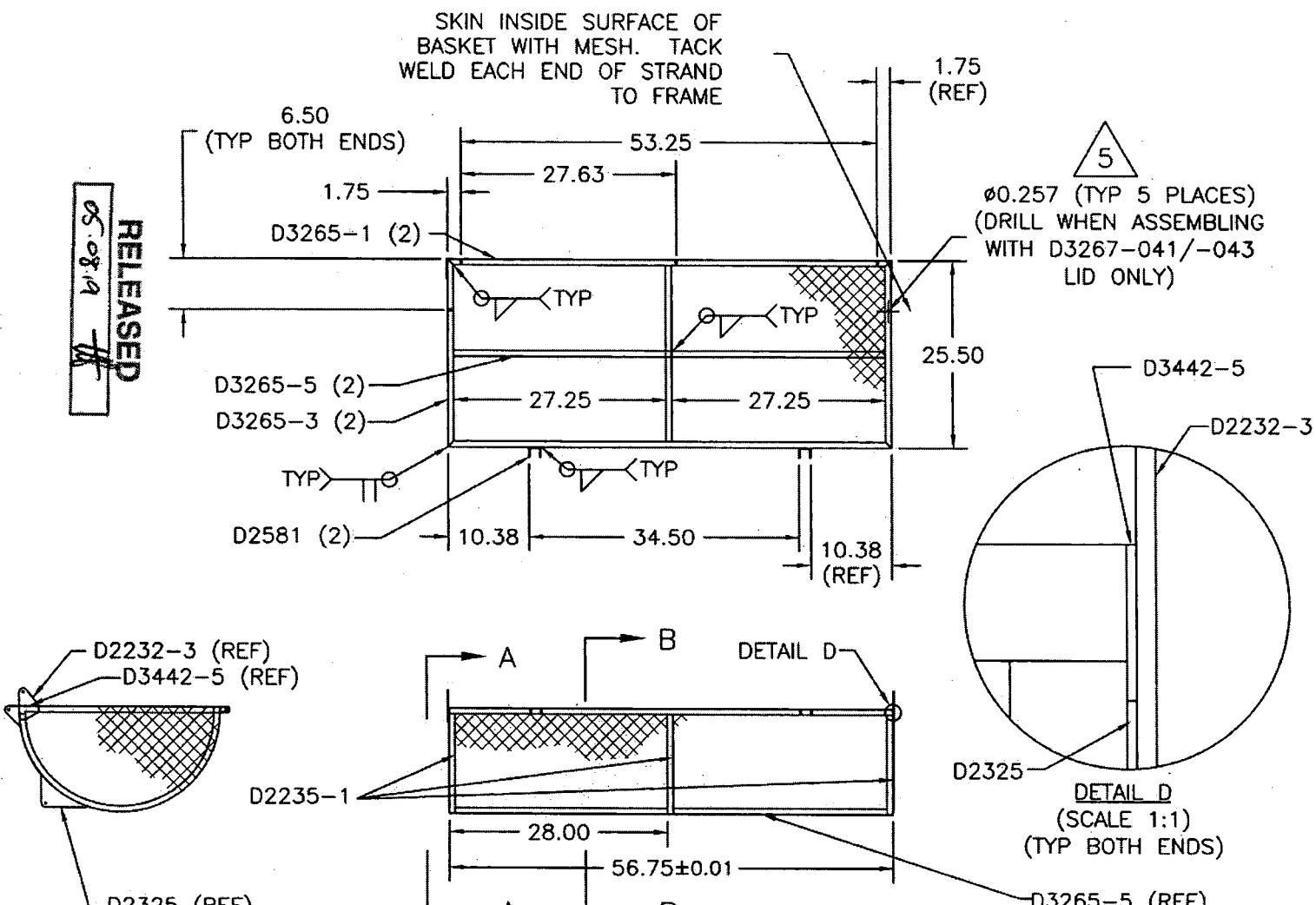
- 1) CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST
 - 2) MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.060 WALL SQUARE TUBING
(REF. DART SPEC M304TS0.750W.060)
 - 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) ALL DIMENSIONS ARE IN INCHES
 - 5) DRILL Ø0.257 HOLES ONLY WHEN ASSEMBLING
D3265-041 BASE WITH D3267-041/-043 LID
- SHOP COPY
 RETURN TO
 ENGINEERING
 CONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 27293A

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DART

DESIGN DS	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO. D3265 SHEET 2 OF 3
DATE 05.06.08	TITLE BASKET BASE ASSEMBLY (350)	SCALE 1:20

**D3265-041 BASKET BASE ASSEMBLY**MESH MATERIAL: 3/4-16F EXPANDED SS (REF DART SPEC M304EX0.75-16F)
SHOP WELD PER DART QSI 004

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

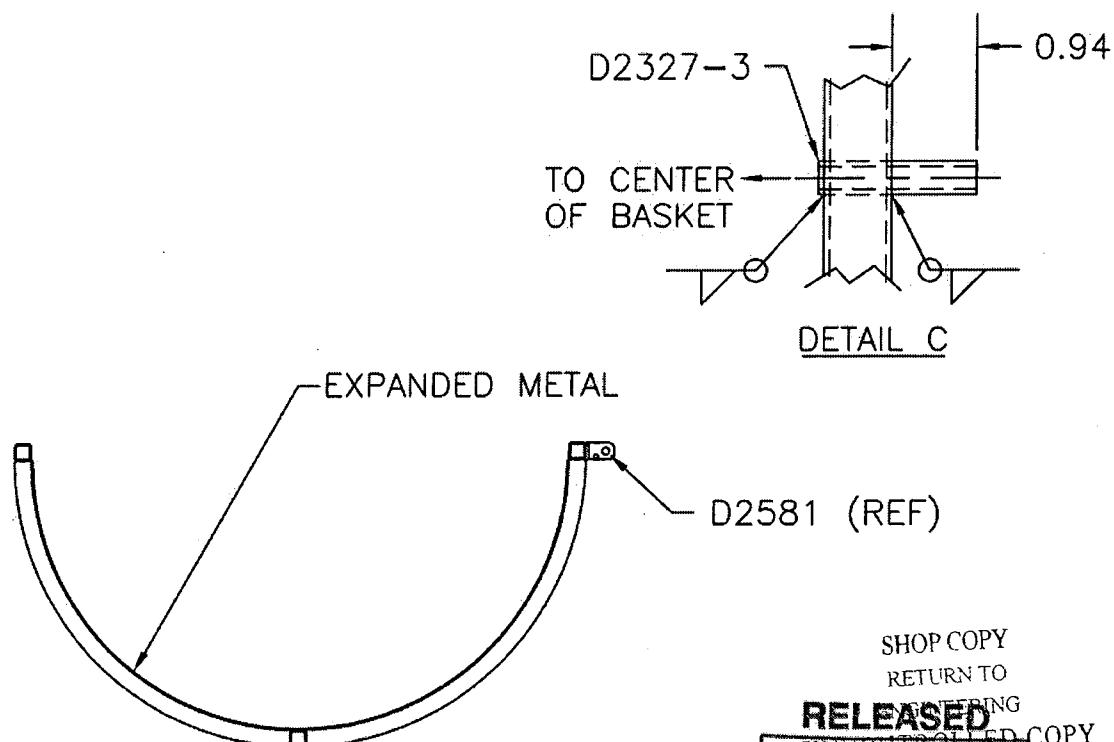
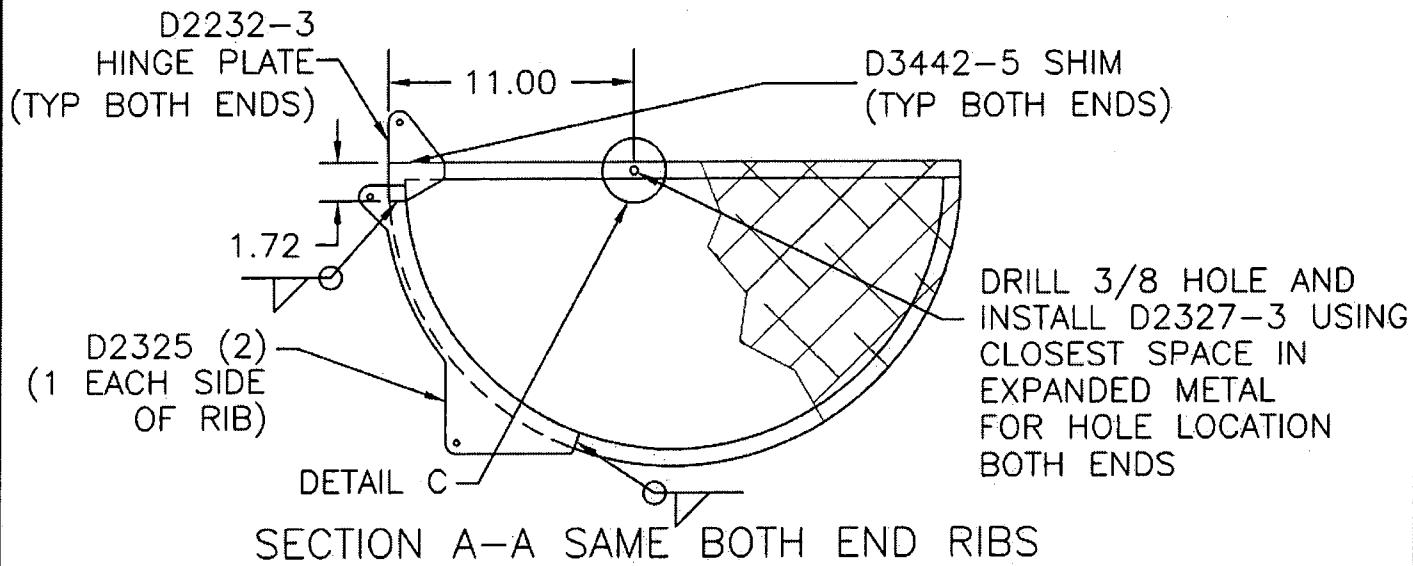
FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3

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WORK ORDER
NO. *2727A*

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ENGINEERING
COPY

DART

DESIGN DS	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>PH</i>	DRAWING NO. D3265	REV. B SHEET 3 OF 3
DATE 05.06.08		TITLE BASKET BASE ASSEMBLY (350)	SCALE 1:8



SECTION B-B SAME BOTH CENTER RIBS

SHOP COPY

RETURN TO

ENTERING

RELEASED
ON CONTROLLED COPY

05.08.04

SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. 27293A

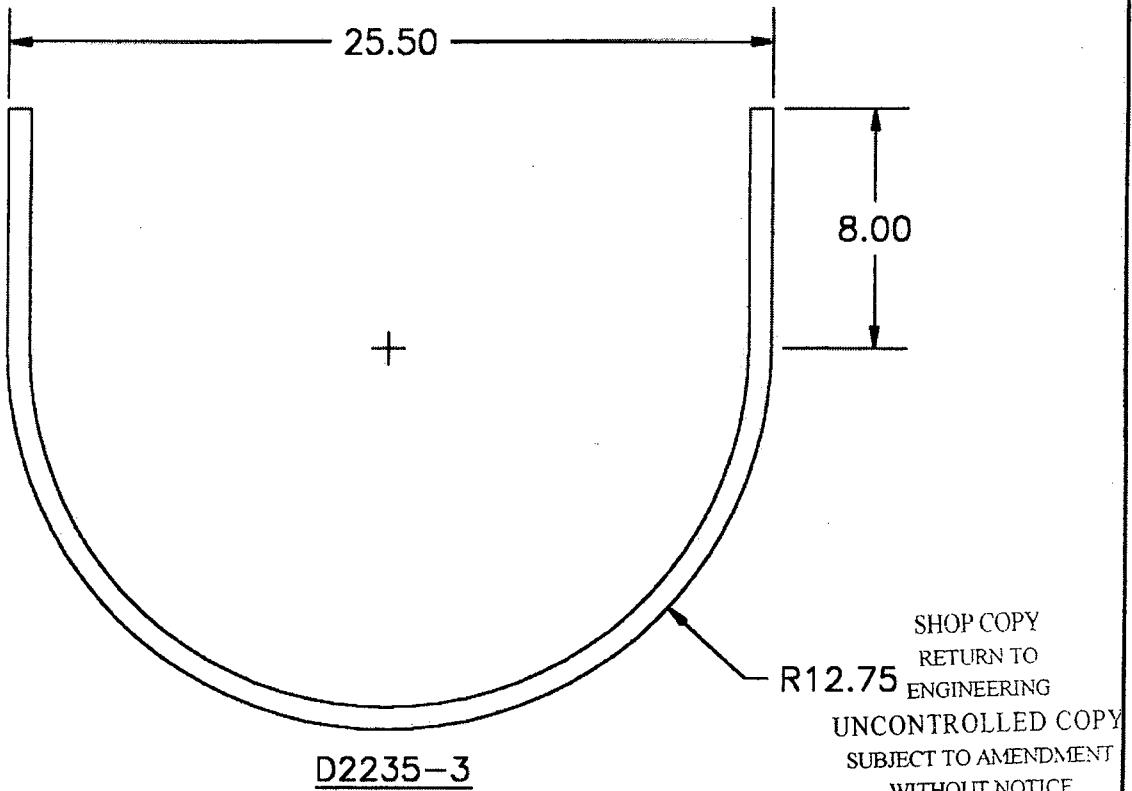
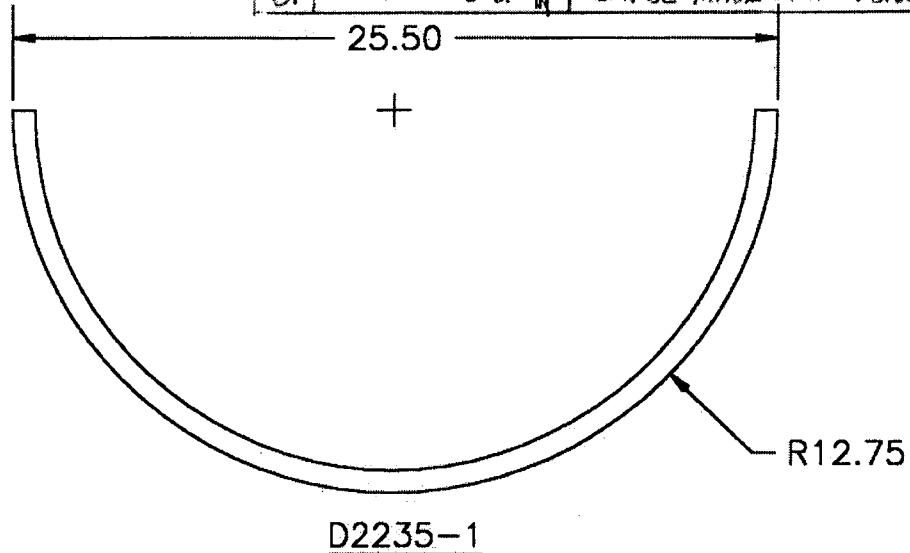
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DART

DESIGN B WILLIAMS	DRAWN BY B WILLIAMS	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>BW</i>	APPROVED <i>BW</i>	DRAWING NO. D2235	REV. B SHEET 1 OF 1
DATE 94:12:16	TITLE BASKET RIBS		SCALE
	BI 02.08.06 <i>P-H</i>	CAN BE MADE FROM D3166-1	

RELEASED
LOS-O-07
9696



CAN BE MADE FROM D3166-1 BI

MATERIAL: 304/316 SS, 3/4 X 3/4 X 0.063 WALL SQR.